

October-30-13 3:16:29 PM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

?

Cust Item ID:

Start Date: 10/30/13 **Start Qty:** 2.00

2

Customer:

Required Date: 11/01/13 **Req'd Qty:** 2.00

Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

Work Order ID 108965

108965

Page 2

October-30-13 3:16:29 PM

Item ID: D044-717-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cold Weather Baffle

Start Date: 10/30/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 11/01/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					2		13/11/11	DAS 6 9.89
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-717-011								
	Location: 041								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

9/13/11-05

9/13-11-04

Picklist Print

October-30-13 3:16:28 PM

Page 1

Work Order ID: 108965
Parent Item: D044-717-011
Parent Item Name: Cold Weather Baffle

Start Date: 10/30/13
Start Qty: 2.00

Required Date: 11/01/13
Required Qty: 2.00

Comments: IPP Rev:B Removed Manufacturing 05-12-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3276-041 Baffle Assembly LH		Manufactured	No			110	Each	6.0000	1	2		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST182		6							
				79169		6							
D3276-042 Baffle Assembly RH		Manufactured	No			110	Each	10.0000	1	2		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST182		10							
				75134		2							
				76168		2							
				79183		6							
D3383-1 Placard		Manufactured	No			110	Each	27.0000	1	2		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST040		27							
				59381		2							
				75135		10							
				76967		15							
AN526G1032R7 Screw		Purchased	No			110	Each	126.0000	8	16		DAS 28 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST346		126							
				123831		26							
				M126175		100							

13-10-31

2x

2x

2x

16x

Picklist Print

October-30-13 3:16:29 PM

Page 2

Work Order ID: 108965
Parent Item: D044-717-011
Parent Item Name: Cold Weather Baffle

Start Date: 10/30/13

Required Date: 11/01/13

Start Qty: 2.00

Required Qty: 2.00

~~MS20426AD3-4~~

Purchased No

110 Each

9,566.0000

16

32

RIVET

DAS 13-10-31

28
9-89

Location

Loc Qty

Loc Code

DAS
6
9-89

ST334

35

123164

35

ST505

1411

104374

12

123021

12

124814

1387

ST509

8120

124586

120

125578

8000

32x

DAS
27
9-89

2X

~~MS21059L3~~

Purchased No

110 Each

162.0000

8

16

Nut Plate

DAS

28
9-89

Location

Loc Qty

Loc Code

DAS
6
9-89

ST316

151

124291

7

125535

3

m126275

41

m127304

100

ST506

11

124308

11

16x

DAS
27
9-89

2X

October-30-13 3:16:29 PM

Shop Packet Print

Page 2

2.0 GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

These installations should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D044-717. Refer to the Aircraft Maintenance Manual for standard shop practices not referred to in these Installation Instructions.

3.0 INSTALLATION PROCEDURE

The Dart D044-717-011 Cold Weather Baffle Kit should be installed as follows:

- 3.1 Temporarily locate the D3276-041 Baffle Assembly on the LH inlet as shown in Figure 1. Transfer drill the 4 holes to the aircraft and enlarge to $\varnothing 0.203$ " (5.20mm). Ensure minimum edge distance of 0.300" from center of hole to edge of opening.
- 3.2 Drill $\varnothing 0.098$ " holes for MS20426AD3-4 rivets that will be used to install the MS21059L3 nutplates. C'sink $\varnothing 0.179$ "x100° (4.55mm x100°).
- 3.3 Deburr all drilled/c'sink holes and touch-up with primer per the Aircraft Maintenance Manual.
- 3.4 Install MS21059L3 nutplates on a/c holes using MS20426AD3-4 rivets. Install the D3276-041 Baffle Assembly using AN526C1032-7 screws. Torque screws 15-25 in-lb (2-3 Nm)
- 3.5 Repeat installation for RH side using D3276-042 Baffle Assembly.
- 3.6 Install D3383-1 Placard in full view of the pilot.

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-717-011	0.86 lb	0	0	160 in	138 in-lb
Cold Weather Baffle Kit	0.39 kg	0	0	4.06 m	1.6 m-kG

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D044-717-011	COLD WEATHER BAFFLE KIT
1	D3276-041	BAFFLE ASSEMBLY, LH
1	D3276-042	BAFFLE ASSEMBLY, RH
1	D3383-1	PLACARD
8	AN526C1032-7	SCREW
16	MS20426AD3-4	RIVET
8	MS21059L3	NUTPLATE

Work Order ID 108965

October-30-13 3:16:29 PM

108965

Page 1

Item ID: D044-717-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cold Weather Baffle

Start Date: 10/30/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/01/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

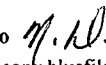
Draw Nbr	Revision Nbr
----------	--------------

N/A	Rev N/A
-----	---------

100		0.00
-----	--	------

100

DOCUMENT CONTROL

DC	Memo 	0.00
----	--	------

Document Control

Photocopy bluefile and create labels per PPP D044-717-011CHG001

MLJ 13-11-01



110	Pick Kit	0.00
-----	----------	------

110

Packaging	Memo	0.00
-----------	------	------

Packaging

DAS

28

8-09

2X

13-10-31

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120

QC	Memo	0.00
----	------	------

Quality Control